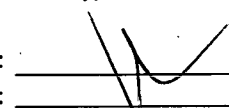
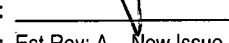


Date: Monday, 15/10/2007 12:38:29 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT PLATE ASSEMBLY
Job Number	: 35169		
Estimate Number	: 12304		
P.O. Number	: <i>NIA</i>	Part Number	: D3467045
This Issue	: 15/10/2007 S.O. No. : <i>NIA</i>	Drawing Number	: D3467 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 34438	Material	: <i>NIA</i>
Written By	: 	Due Date	: 22/10/2007 Qty: 5 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev: A New Issue 06-04.24 EC Est Rev: B As per Rev B 06-05-24 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3467049	BAFFLE & DEFLECTOR ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch	
1	D3467-49	Baffle ass'y	<i>34490</i> (4)	<i>B 35190</i> (1) <i>mf</i>

2.0	D34673	TUBE
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch	
2	D3467-3	Tube	<i>B 34099</i>	<i>x 3 mx, B 34695 x 9 mx. mf</i>

3.0	D34675	AFT PLATE
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch	
1	D3467-5	aft plate	<i>B 34100</i>	<i>mf</i>

4.0	D346711	BRACKET
-----	---------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch	
2	D3467-11	Bracket	<i>B 34094</i>	<i>x 1 mx, B 34491 x 9 mx. mf 07-10-25</i>

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-10-25							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-25	9	- spot weld made hole in metal piece	all 29	- <del>weld on hole</del> fill hole. weld a bit.	07-10-25 Chow	✓ 07/10/29	all 29	07/10/29

NOTE: Date & initial all entries

Date: Monday, 15/10/2007 12:38:29 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT PLATE ASSEMBLY

Job Number: 35169

Part Number: D3467045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D346717

TOP COVER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description  
1 D3467-17 Shourd Plate

Batch

B 34095

mf

6.0

D346719

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description  
1 D3467-19 Doubler

Batch

B 34096 x 4mx, B 32047 x 1mx

mf

7.0

D346720

doubler RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description  
1 D3467-20 Doubler

Batch

B 34098 x 5mx, ~~B 32048 x 1mx~~

mf

8.0

NAS1031C3W

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nutplate

M105728

mf

07-10-25

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-045

mf

07-10-25

⑤

10.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/11/29

⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 15/10/2007 12:38:29 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT PLATE ASSEMBLY

Job Number: 35169

Part Number: D3467045

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 5 Hubs (X5)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 158

*Handwritten signature*

*Handwritten:* AS 04/11/30

*Handwritten:* (X5)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* (5) 04/11/30

Job Completion



*Handwritten:* U 04/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

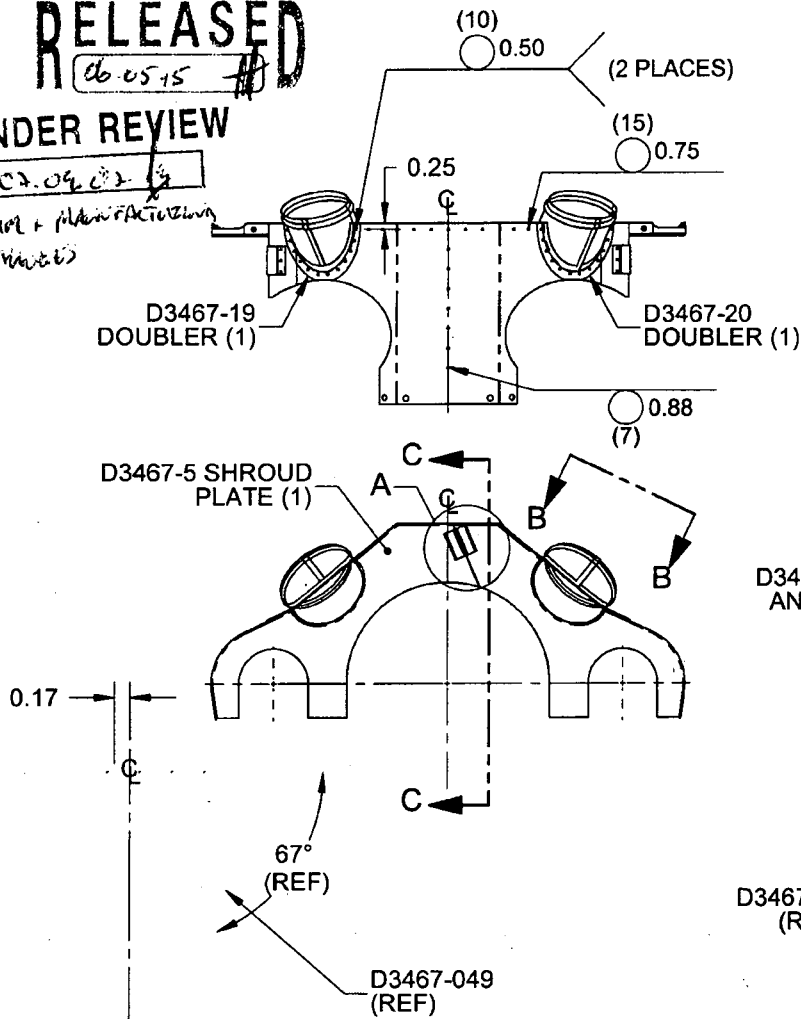
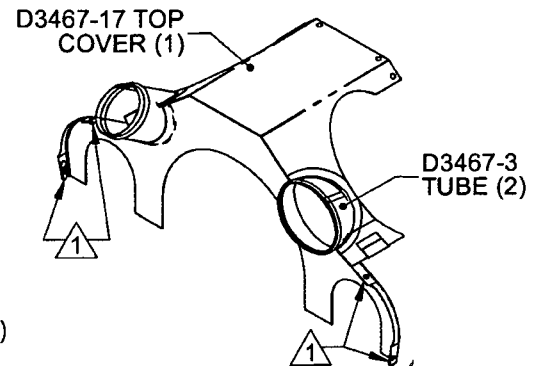
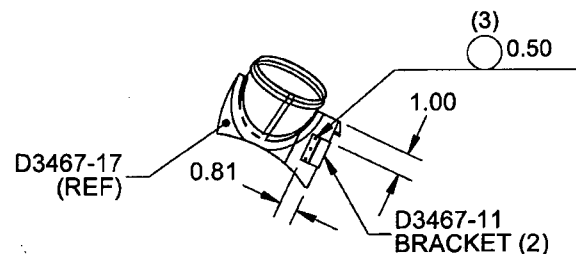
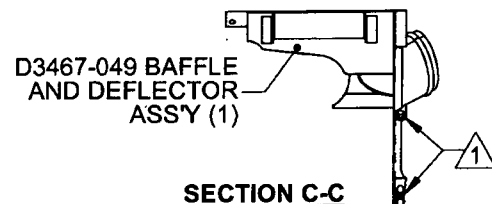
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 3 OF 15
DATE <b>06.05.15</b>	TITLE <b>SHROUD ASSEMBLY</b>		SCALE 1:8

**RELEASED**  
*06.05.15***UNDER REVIEW***02.09.03**Dir + Manufacturing  
Changes***DETAIL A**  
SCALE 1:2*W035169***VIEW B-B: WELDING D3467-11**  
D3467-047 NOT SHOWN FOR CLARITY  
(2 PLACES)**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**SPOT WELD TEST RECORD**  
**AMS-W-6858A**  
**CLASS 'C'**

**TEST NO#:** 43

**EMPLOYEE:** Melanie Fauten

**PART NUMBER:** D 3467-045

**JOB NUMBER:** B 35169

**MATERIAL TYPE:** 304L

**MATERIAL THICKNESS:** 0.08

**GROUP SPECIFICATION**

☐

**Group 1: Aluminum & magnesium**

☐

**Group 2: Iron; nickel; cobalt**

☒

**Group 3: Titanium SS**

**TEST RESULTS**

	PASS	FAIL	
<b>VISUAL:</b>	[ <u>/</u> ]	[   ]	
<b>PENETRATION:</b>	[ <u>/</u> ]	[   ]	
<b>PULL STRENGTH:</b>	[ <u>/</u> ]	[   ]	<b>PSI Reading:</b> _____

**Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)**

**DATE OF TEST COUPON:** 07/11/29  
**QUALIFIER:** 813